

Date: Tuesday, 15/07/2008 4:12:05 PM  
 User: Julie Lecocq

## Process Sheet

Split.

|                       |   |                  |                               |
|-----------------------|---|------------------|-------------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services   | Drawing Name     | : BEARING                     |
| Job Number            | : 40518   |                  |                               |
| Estimate Number       | : 10807   |                  |                               |
| P.O. Number           | :   | Part Number      | : D2611                       |
| This Issue            | : 15/07/2008 S.O. No. :   | Drawing Number   | : D2611                       |
| Prsht Rev.            | : NC  | Project Number   | : N/A                         |
| First Issue           | : / / Type : PURCHASED PARTS  | Drawing Revision | : REV.C                       |
| Previous Run          | : 39124   | Material         | :                             |
| Written By            | :   | Due Date         | : 31/07/2008 Qty: 80 Um: Each |
| Checked & Approved By | : <u>JUL 08.7.16</u>  |                  |                               |
| Comment               | : Est Rev.B 99.06.23 Re-format DM<br>Change to SS; Change Supplier- Rev.C 07.03.14 EC |                  |                               |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |    |            |
|-----|----|------------|
| 1.0 | PG | PURCHASING |
|-----|----|------------|



Comment: PURCHASING

Issue P/O: 6788C208107/16

Purchase part as per Dwg D2611

Possible supplier: McMaster

P/N: 63215K34

(80)

Material release note required

|     |          |         |
|-----|----------|---------|
| 2.0 | 63215K34 | Bearing |
|-----|----------|---------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 80.0000 Each(s)

Bearing

|     |             |                       |
|-----|-------------|-----------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure certificate of conformity is attached

AS 08/07/17

(x20)

|     |     |                   |
|-----|-----|-------------------|
| 4.0 | QC6 | DIMENSIONAL CHECK |
|-----|-----|-------------------|



Comment: DIMENSIONAL CHECK

S 08/07/17

(x20) counter

|     |             |                       |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 388/7/16

x20

SP

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 4:12:05 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING

Job Number: 40518

Part Number: D2611

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/18 *JS*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*u 08-07-18*



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

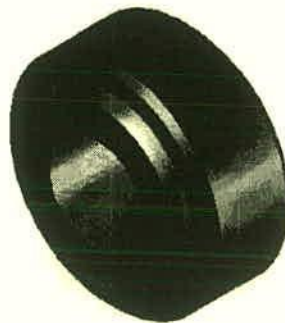
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

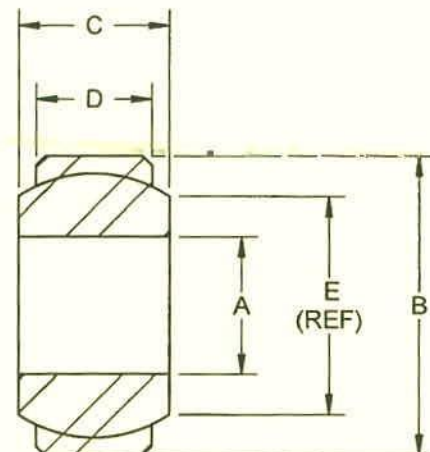
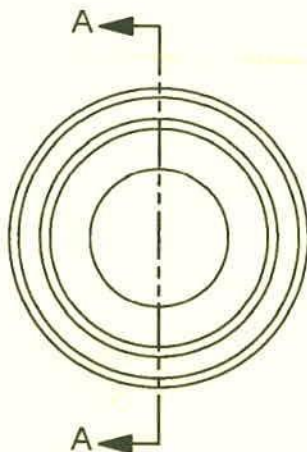


|                  |                  |   |                        |
|------------------|------------------|---|------------------------|
| DESIGN<br>GP     | DRAWN BY<br>CB   | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>HA    | APPROVED<br>HA   | DRAWING NO.<br>D2611                              | REV. C<br>SHEET 1 OF 1 |
| DATE<br>06.09.20 | TITLE<br>BEARING |   | SCALE<br>NTS           |
| REV              | DATE             | DESCRIPTION                                       |                        |
| A                | 97.07.31         | NEW ISSUE   |                        |
| B                | 01.07.04         | RE-DRAWN  |                        |
| C                | 06.09.20         | CHANGE TO SS; CHANGE SUPPLIER                     |                        |

## SPECIFICATION CONTROL DRAWING



RELEASED  
06.11.17 HA



SECTION A-A



| A     | B     | C     | D     | E (REF) | POSSIBLE SUPPLIER          |
|-------|-------|-------|-------|---------|----------------------------|
| 0.375 | 0.813 | 0.406 | 0.313 | 0.592   | McMASTER-CARR P/N 63215K34 |

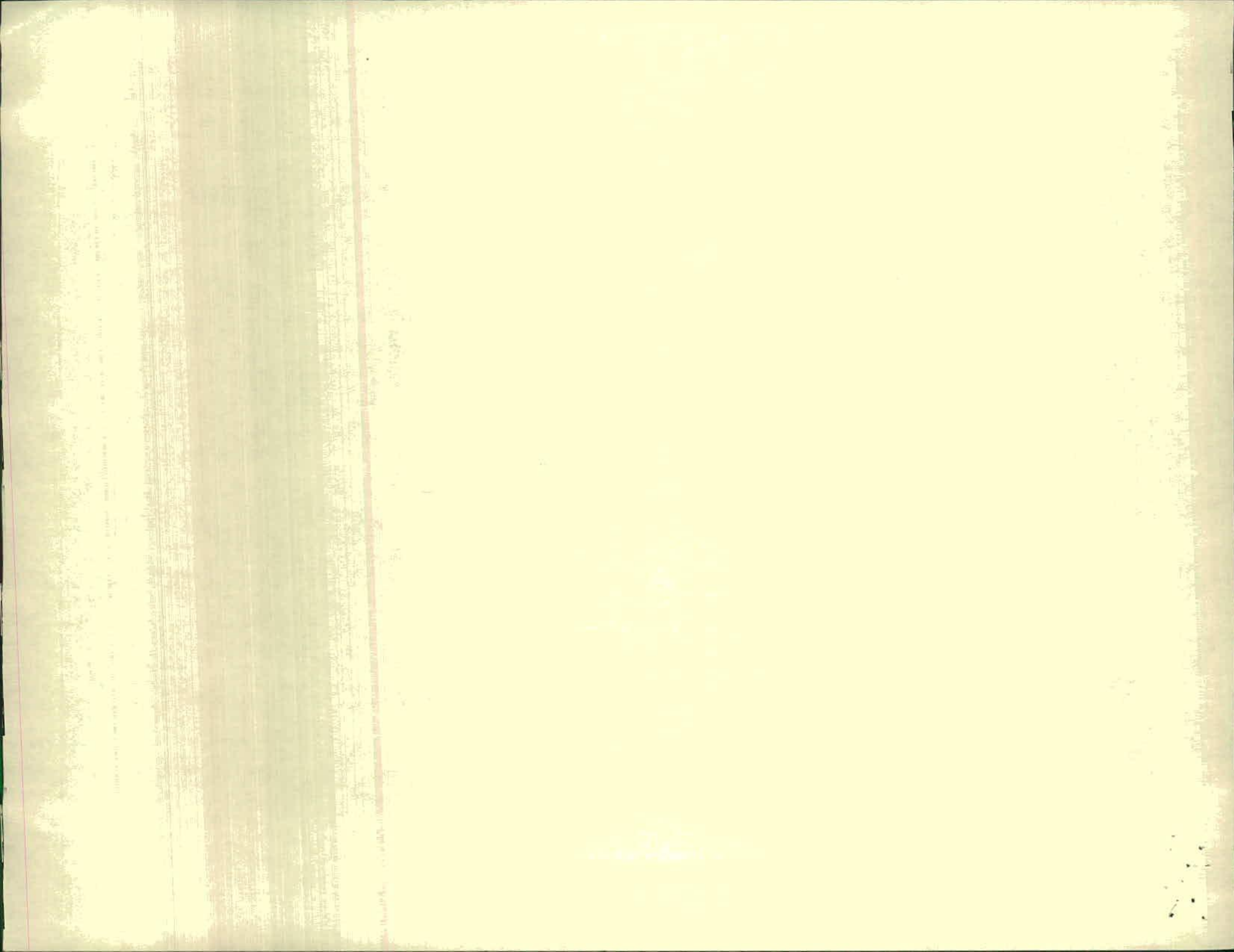
NOTES:

- 1) STAINLESS STEEL BALL JOINT SWIVEL BEARING
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40518

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# McMASTER-CARR®

Aurora Industrial Pkwy  
 Aurora, OH 44202-8087  
 955-5500  
 sales@mcmaster.com

Dart Aerospace Ltd  
 1270 Aberdeen St  
 Hawkesbury ON K6A 1K7  
 Canada  
 Attention: Main Finished Goods Location

Purchase Order  
 PO00000708

6788 5

McMaster-Carr Number  
 4027485-01

Page 1 of 1

07/16/2008

| Description | Ordered | Shipped |
|-------------|---------|---------|
|-------------|---------|---------|

|  |            |    |
|--|------------|----|
| 3 - 299 - 05<br>23 - 52<br>K34<br>20 EA<br>1 | 80<br>Each | 20 |
|--|------------|----|

3 - 299 - 05 23 - 52 K34 20 EA 1

5 06/07/17

to ship

|  |            |    |
|--|------------|----|
| 2 - 299 - 05<br>23 - 52<br>K34<br>20 EA<br>1 | 80<br>Each | 20 |
|--|------------|----|

60 to ship by 07/23

Aerospace Ltd

EXP



1 lb  
 1 line

FW1BSP42  
 07/16/2008  
 10:52/11:02  
 107

8020239441178



